Tuesday, 15/05/2007 3:25:20 PM

User

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

Drawing Name

: DOUBLER

Estimate Number

: 31942

: 11169

P.O. Number

ALG:

This Issue

: 15/05/2007

S.O. No. : NA

Part Number

: D32831

Prsht Rev.

: NC : 17/04/2007

: 25339

Drawing Number

Project Number

: D3283 REV D : N/A

: 24/04/2007

Drawing Revision

Material Due Date

Qty:

20 Um: Each

Written By

Comment

First Issue

Previous Run

Checked & Approved By

: Est A 04.09.28

New issue KJ/JLM

: MACHINED PARTS

Additional Product

'Job Number:



Seq. #:

Description:

1.0

M6061T6S063

6061-T6 .063 Sheet



0.2479 sf(s)/Unit Total: 4.9581 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063) Identify for D3283-1 Batch: M/?

SHEAR

2.0 SHEAR

Comment: Qty.:



Comment: SHEAR

Cut blanks: 15.550" x 1.540"

21

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA424 and Dwg D3283

Stack of 10

Identify as D3283-1

4.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | |
|------|------|--|----|---------|-----|-------------------------------|--------------------------|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
| | | Avid etch l'alodine per Dug D3283 1 Q31065 Perm. chg. | | 07a5.28 | | 07052 | 0 Pars 20 | | | |
| | | | | | | | | | | |

| Part No: _ | PAR #: | Fault Category: | NCR: Yes No I | DQA: | Date: 07/06/04 |
|------------|--------|-----------------|---------------|-------|----------------|
| | | | QA: N/C Cld | osed: | Date: |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | | |
|----------|------|---|-------|--|----------|--------------|-----------|--------------|--|--|--|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval | | | | |
| DATE | STEP | Section A Init | | Initial Action Description Sign Chief Eng Chief Eng Date | | Section C | Chief Eng | QC Inspector | | | | |
| 51.05/16 | 2.0 | -drawing shows 57 holes but only 56 are dilled. -part matches with float webs | | drill have manually is cleber. | 70 | | | | | | | |
| 6tos | 3 | -part matches with Float webs | Ciouz | | 07.05.16 | 10708.23 | 65,042 | 1705-2 | | | | |
| | | | | See PARIZA. | 0405723 | 701 | | | | | | |
| | | *************************************** | | | | · | | | | | | |
| | | | į | | | | : | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | / | | | | |

Tuesday, 15/05/2007 3:25:20 PM Date: Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOUBLER Job Number: 31942 Part Number: D32831 Job Number: Seq. #: Description: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE W St. 2604 Job Completion

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | | |
|---------|------|------------------------|----------|-------|-----------|-------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | ' | • | | | | | | | | | |
| | | | | | - | | | | | | |
| | | | | | | | | | | | |
| Part No | : | PAR #: Fault Category: | NCR: Yes | No DQ | A: | Date: | | | | | |

QA: N/C Closed: ____ Date: __

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
|---|------|----------------------------------|----------------------|------------------------------|----------------|-----------|-----------------------|--------------------------|--|--|--|
| | | Description of NC | | Corrective Action Section | Verification | A | A | | | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | | | |
| | | | - T | | | | . • | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| • | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | · | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |



| DESIG | CP | DRAWN BY | DART AEROSPACE USA, INC. | |
|-------|---------|--------------|----------------------------|----|
| CHEC | CED 111 | APPROVED /// | DRAWING NO. REV. | D |
| | AH- | -M | D3283 SHEET 1 OF | |
| DATE | | | TITLE SCA | LE |
| 05.0 | 8.09 | | DOUBLER 1 | :3 |
| Α | | 04.05.06 | NEW ISSUE | |
| В | | 04.08.09 | 10.882 WAS 11.502 | |
| С | | 05.03.16 | CHANGE HOLE PATTERN FOR -1 | |
| D | | 05.08.09 | REDESIGN | |

SPEC. M6061T6S.063).

0.063 THICK (QQ-A-250/11, REF DART

MATERIAL: 6061-T6.

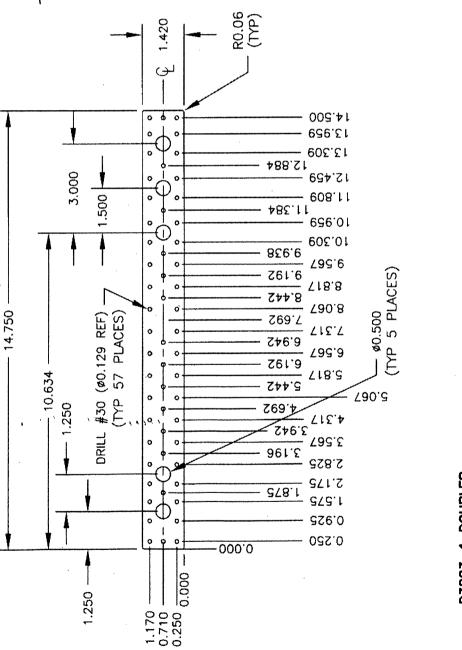
FINISH: CHEMICAL

284

CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

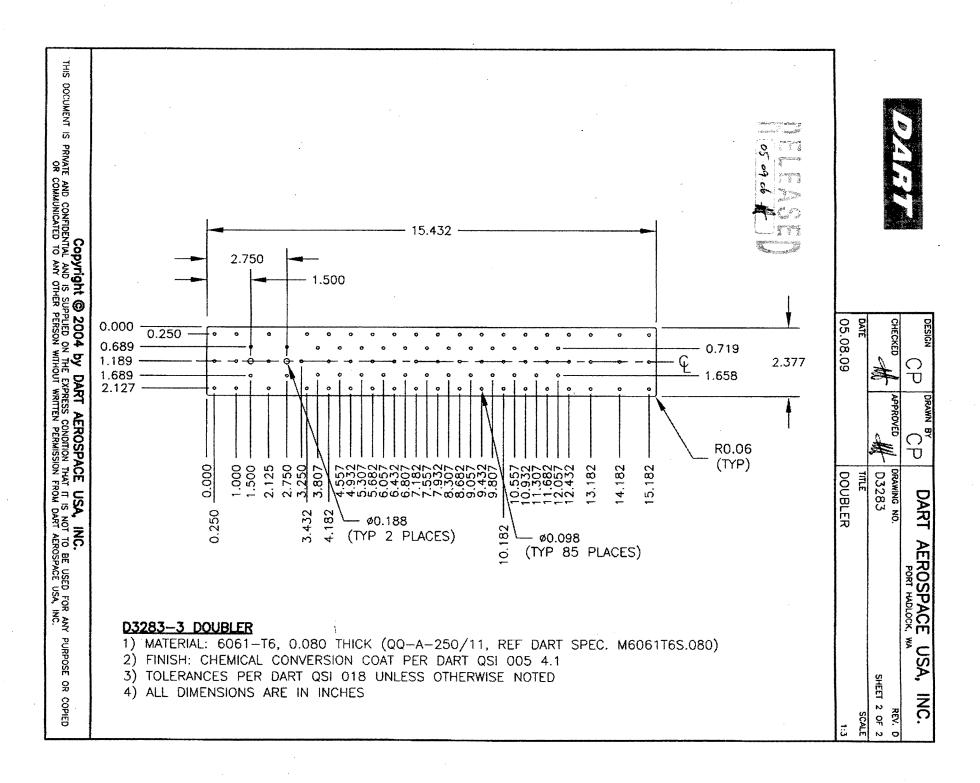
ALL DIMENSIONS ARE IN INCHES



Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

| Dart Ae | rospace | Ltd | | | | | | | |
|---------|---------|-------------------|----------------------|------------------------------|----------------|--------------|------------|-------------------------------------|--------------------------|
| W/O: | | | V | ORK ORDER CHANGES | | | | | |
| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date | e Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| · | | | | | | | | | |
| | | · | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Part No | : | PAR #: | _ Fault Ca | tegory: NC | R: Yes | No DQ | A : | _ Date: _ | |
| | | | | | QA: N | C Close | d: | Date: | |
| NCR: | | W | ORK OR | DER NON-CONFORMANCE | (NCR |) | | | |
| | | Description of NC | | Corrective Action Section B | Section B | | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Secti | 1 | Chief Eng | QC Inspector |
| | | | | | | | | | |
| | | • | | | | | | | |
| | | | | | | | | | |
| | | | _ | | | | | | |



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | | |
|---------|------|---------------------------|--------|------------|-----|-------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
| | | | | | | ÷ | .• | | | | |
| | | | | · 6 | | | | | | | |
| Part No |): | PAR #: Fault Category: NC | R: Yes | No DQ | A: | Date: | | | | | |

QA: N/C Closed: ____ Date: ___

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
|--------|------|--|----------------------|--------------------------------|--------------|-----------------------|--------------------------|--|--|--|--|
| | | Description of NC | | Corrective Action Section B | Verification | Approval | A 1 | | | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | | | | |
| | | • | · | | | | | | | | |
| | , | and the second s | | | ! | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | · deff _{eren} | | | | | | | | | |
| | | | | | | | | | | | |
| | | · · · · · · · · · · · · · · · · · · · | | | | | | | | | |
| Į Į | | | | | | | | | | | |
| | | | | | | | | | | | |

| DART AEROSPACE LTD | Work Order: 31942 |
|------------------------------|--------------------------|
| Description: Serbles | Part Number: 13 32 5 3-/ |
| Inspection Dwg: 73283 Rev: > | Page 1 of 1 |

675

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | Prototype |
|---|---------------|-----------|
|---|---------------|-----------|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| 14,750 | 2-010 | 14.70 | | | Tope | |
| 10.634 | 1-00 | 60,632 | | | , | |
| 1.250 | ± -010 | 1-250 | | | | |
| 1,250 | 7 -010 | 1-250 | | | | 3 |
| 1.500 | 7-010 | 1.500 | | | | ** |
| 3,000 | ∽. 070 | 3.000 | | | | |
| 1.170 | *·010 | 1.170 | | | | |
| .710 | 2.010 | .710 | | 1. | | |
| -250 | ~010 | -250 | | | | |
| 1.420 | ±,000 | 1.422 | | - | Ž. | 1604467 |
| 0.500 | | 0.502 | | | | |
| 0.129 | | 0.131 | | | | |
| AND 74 | | | | | | |
| | | | | | | |
| | | | | | | |
| | | * . | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | 3 | , 74 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | Audited by: | Prototype Approval: | |
|----------------|----------------|---------------------|--|
| Date: 07.03.16 | Date: 07/05/15 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| Α | | New Issue | KJ/JLM | |

